

Work Order ID 56951

March 15, 2010 1:20:30 PM



Page 1

Item ID: D4016-5

Accept



Setup Start



Revision ID:

Item Name: Hinge Half, Light Lid

Stop



Start Date: 16/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 10.00



Customer:

Reference:

10/03/15

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Date: Set Up/ Run Hours | Date: Draw Number | Date: Draw Rev. | Date: Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|-------------------------------|-------------------------|-----------------------|-----------------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|-------------------------------|-------------------------|-----------------------|-----------------------|---------------|---------------|------------------|----------------|

| | |
|----------|--------------|
| Draw Nbr | Revision Nbr |
|----------|--------------|

| | |
|-------|---|
| D4016 | A |
|-------|---|

| | |
|-----|-------------------------|
| 100 | Cut blanks as per folio |
|-----|-------------------------|



Bandsaw

Jeaspa Bandsaw

Memo

1" Long
CUT BLANK as per folio

0.00

8.5 10/03/17

10 6

110



HAAS I

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA874 AND DWG
FOLIO REV: A
DWG REV: A

0.00

8.5 10/03/17

10 6

DEBURR

Work Order ID 56951

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

2.5 10/03/19

10 6

Quality Control

130



QC

QC8- Inspect parts - second check

0.00

DJT 16/03/19

10 6

Quality Control

160



Packaging

Identify as per dwg & Stock Location: 109

0.00

PAJ0

0.00

PDT 13/3/22 (10)

Work Order ID 56951

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Start Date: 16/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

170



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Memo

0.00

10/03/24

K10-3-22

(10)

Picklist Print

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Page 1

Work Order ID: 56951



Parent Item: D4016-5



Parent Item Name: Hinge Half, Light Lid

Start Date: 16/03/2010

Required Date: 26/03/2010

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY:DD IPP Rev:B
as per dwg REV.A DD 10.02.22 verified by:EC

Start Qty: 10.00

Required Qty: 10.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6B0.750X00.75 0 | | Purchased | No | | | 100 | f | 20.7727 | 0.9474 | | | |



6061-T6 Bar .750 x .750

| <u>Warehouse</u> <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-------------------------------------|----------------|-----------------|
| Main Warehouse | | |
| MAT | 20.77265632 | |
| 107387 | 2.49 | |
| 108877 | 3.3453 | |
| 112567 | 14.9373563 | |

.2474

1.5 10/03/17

| | | |
|---------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 56951 |
| Description: Basket Hinge | Part Number: | 4016-5 |
| Inspection Dwg# 4016 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | |
|-------------------------|------------------------|-------------------------|
| Measured by: <u>S.P</u> | Audited by: <u>DTP</u> | Prototype Approval: N/A |
| Date: <u>10/03/19</u> | Date: <u>10/03/19</u> | Date: N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New issue | KJ/JLM | |

8

7

6

5

4

3

2

1

D

D

C

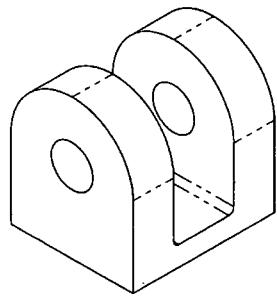
C

B

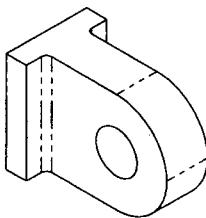
B

A

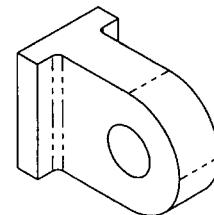
A



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



D4016-5 HINGE HALF, LIGHT LID

sb95
RELEASED
R 2010-02-16
m

| A | NEW ISSUE | | JPH | 10.01.29 |
|------------|-------------|---|--------------|----------|
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | AJS | DRAWING NO. | REV. A | |
| CHECKED | R | D4016 | SHEET 1 OF 2 | |
| MFG. APPR. | R | TITLE | SCALE | |
| APPROVED | R | BASKET HINGE | NTS | |
| DE APPR. | R | | | |
| DATE | 10.01.29 | | | |

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8

7

6

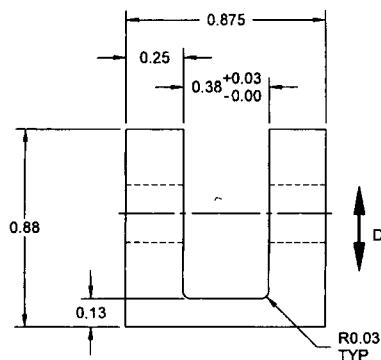
5

4

3

2

1



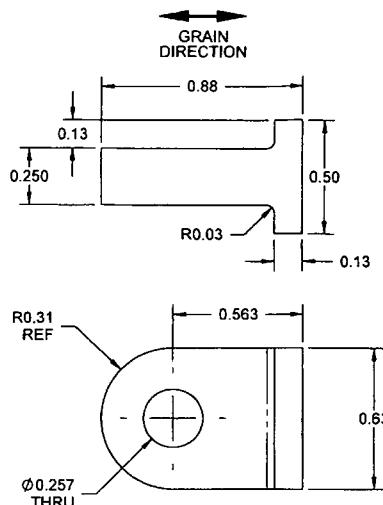
D4016-1 HINGE HALF, BASE

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.09 lbs
-3: 0.04 lbs
-5: 0.01 lbs



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

56951
RELEASED
2010-02-16
M

| | | |
|------------|----------|-----------------------------|
| DESIGN | AJS | DART AEROSPACE LTD |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | 00 | DRAWING NO. |
| MFG. APPR. | BS | REV. A |
| APPROVED | W0 | D4016 |
| DE APPR. | MM | SHEET 2 OF 2 |
| DATE | 10.01.29 | TITLE SCALE NTS |

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